Work Orde Wednesday, July				*103	8891*						Page 1
Item ID: Revision ID:	D3009-3			Accept	*N900	040	100)*	Setup Star	1.71	S1*
Item Name:	Cup								Stop	, *N	S2*
Start Date:	7/3/2013	Start Qty: 60.00	*60*		Cust Item II	D :					
Required Date: Reference:	7/15/2013	Req'd Qty: 60.00	*60*		Customer:						
Approvals:	Process Pla	ın: CL	Date: 13/07/C	Tooling:	Da	te:			Run Star	1/7	R1*
	QC:		Date:	SPC (Y/N):	Da	te:			Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3009	Rev	В									
*100 *100* Hardinge Härdinge CNC Lath	ne Small	Hardinge CNC LATHE Memo 1-TURN A: FOLIO REV DWG REV	S PER FOLIO FA130 & D	0.00 WG D3009 Z	13-7-12			70	4		T _g
			AS REQUIRED .						/		,
*110 *110* QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00	13-7-12			70	\$		

Work Orde Wednesday, July				*103891*									
Item ID: Revision ID: Item Name:	D3009-3 Cup			Accept	*N90	*N90004010)* s	setup Star	IV	S1* S2*	
Start Date: Required Date: Reference:	7/3/2013 7/15/2013	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Item ID: Customer:			_	n	. Star			
Approvals:	Process Pl	an:	Date:	Tooling:	Date:				К	tun Stai Sto	1/1	R1*	
	QC:		Date:	SPC (Y/N):		Date	e:			510	* *N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool l	ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*120 *120*		QC8- Inspect parts - secon	nd check	0.00	720	3	7.1	4	70	4			
QC Quality Control		Memo		0.00								-	
130		Identify as per dwg & Stor	ck Location: W/A	0.00					20		<i>(</i> 2 . 7	- 1/	
130 Packaging Packaging		Memo *****STOCk	(IN LARGE FAB****	0.00						_EL	13.7	. <u>/3</u>	
¹¹⁴0 *1⊿∩*		QC21- Final Inspection -	Work Order Release	0.00						13/	7/17	4	
QC Quality Control		Мето		0.00						•	MF 13	n-15	

Picklist Print

Wednesday, July 03, 2013 12:36:47 PM

Work Order ID:

103891

Parent Item:

Comments:

D3009-3

Parent Item Name:

Cup

IPP A 07.12.18new issue EC

IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD veryfied by:ec

Start Date: 7/3/2013 **Start Qty:** 60.00

Loc Code

Required Date: 7/15/2013

Page 1

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			110	f	27.4040	0.0479	3.0252632	2)	13	-7-12
304 round bar 1.00									· · · · · · · · · · · · · · · · · · ·				

Location Loc Qty 27.404 MAT029 3.404 123313 24 m126151

DART AEROSPACE LTD	Work Order:	103891
Description: Cup	Part Number:	D3009-3
Inspection Dwg: D3009 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.875	+0.000/-0.005	,8723			b-7	Vez
Ø0.750	+0.008/-0.001	750				
Ø0.266	+0.006/-0.001	-266			!	
R0.062	+/-0.010	R.062				1
0.094	+/-0.010	093	/			
0.353	+/-0.010	352				
, 0.063	+/-0.010	-084		:		
X0.032 x 45°	+/-0.010	.03 145				
						(2)
		The state of the s				
	٠.					
L	1	1			·	<u> </u>

Measured by: Audited by: Prototype Approval: N/A

Date: 3-7-14

Date: 8.7-14

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.22	New Issue	KJ/EC/DD	X
			• ()	

D D R0.062 --R0.032 x 45° CHAMFER 0.094 (REF) SECTION A-A С ulo 103891 Ø0.266 (DRILL 17/64", REF) THRU Ø0.750 Ø0.875^{+0.000}_{-0.005} D3009-1 CUP REDRAW/REFORMAT DWG, D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2) 07.12.12 NEW ISSUE RF 01.03.23 Α DESCRIPTION BY DATE REV. NOTES:
1) MATERIAL:AISI 1018-1025 ROUND BAR
(REF DART SPEC M1018-R)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs DESIGN DART AEROSPACE LTD Α

7

DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3009 MFG. APPR.

SHEET 1 OF 2 TITLE APPROVED SCALE CUP DE APPR. 2:1 DATE

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195 DOCUMENT IS PRIVATE AND COMPRISHING AND IS SEPALED OF THE EXPRESS CONDITION THAT IT IS

NOT TO BE USED FOR ANY PAPPOSE OF COMED ON COMMENCATED TO ANY OTHER PERSON WITHOUT
WRITTEN PRIVATED ON PROMISHON FOR DART AEROSPICE LTD. 07.12.12

3

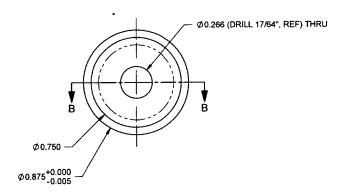
2

5

8

DQA:		– Date:	<u></u>		WORK ORDER NON CONFORMANCE (LIRDATE									
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
Work Orde	r·				DISPOSITION									
Part No.					Rework Scrap		}— —	osstube mall Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
NCR No.					Use-as-is Suspected Unapproved		Thermoforming Finishing Large Fab Composite				re/Packaging Supplier	Other		
Root		T		Desc	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	1	ief Eng	Description	n	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
						FAI	ULT CAT	EGORY						
Landir	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set			Outside Dime Over/Under Part Incorred Part Lost/Mis Part Moved Positioned W Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
.		Sequence wist in Tul		-	Finish Fit/Function	-	1	Calibration						

R0.062 -R0.032 x 45° CHAMFER 0.094 0.353 0.063 (REF) SECTION B-B



D3009-3 CUP

D

NOTES:
1) MATERIAL:AISI 304/316 STAINLESS STEEL ROUND BAR (REF DART SPEC M304R)
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

8

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN DRAWING NO. CHECKED REV. B D3009 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE CUP DE APPR. 2:1 DATE 07.12.12

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2

3

DQA:			. Date:												
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
						DISPOSITION			AGA						
Work Orde	er: _									. —					
Part No.					Rework Scrap			—	stube III Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
, are r	-					Use-as-is	1		·	ishing	1	e/Packaging	Other		
NCR No.				Suspected Unapproved		incii		posite	1100	Supplier					
Root	Desc				Desc	ription of work order update		nitial	Action	•	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design															
Doc/Data			1												
Equip/Tooling	Ш														
Handling/Pre	\Box										:				
Material	\Box					·									
Operator															
Offset/Setup	Щ														
Process	\Box		ļ						·			!			
Supplier	\Box														
Training															
Transport															
Unapproved			<u> </u>		İ										
							FAI	ULT CA	TEGORY			·			
Landii					_	General		1			1	_	¬		
	-	Bending	_		\vdash	Bend	<u></u>	1	Program		Outside Dim	 	Pressure/Forced		
	\vdash	Centre Not Concentric				BOM/Route		Grain			Over/Under	<u> </u>	Set-up		
	Cracks					Broken/Damage/Defect	_	Hardwa			Part Incorred	 	Temperature/Cure		
	Crimp/Kink/Ripple/Wave				-	Burrs		1	ion Incomplete/Unqualified	d	Part Lost/Mi	· ·	Weld		
	Cuffs					Contamination	_	4	tions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled		
	Crushing				<u> </u>	Countersink	<u> </u>	1 `	gned/off center	<u> </u>	Positioned V		-		
	Heat Treat Inspection Strip in Tube				\vdash	Cut Too Short	-	Mislabe		L	Power Loss/	Other			
	\vdash	,	•	Tube	-	Drawing	\vdash	Misrea			-				
	$\overline{}$	Marks/Ch			\vdash	Drill Holes	<u> </u>	Off-set							
	$\overline{}$	Turning S			\vdash	Finish	<u></u>	1	Calibration			····			
	Wave/Twist in Tube					Fit/Function	1	Out of:	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH